

Work Order ID 63882 PRELIMINARY ISSUE

Thursday, November 18, 2010 8:26:21 AM

Page 1

Item ID: D4276-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Aft Beam

Start Date: 11/18/2010 Start Qty: 2.00



Cust Item ID:



Required Date: 11/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-11-18 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D4276	PA1

100



BAND SAW

0.00

MATERIAL CERTIFICATION
RECD UPON DELIVERY
C21011123

Bandsaw

Jeaspa Bandsaw

Memo

Cut Blank to 36.630"

Batch: 0107221
M114352

0.00

ark 10/11/18

2 6

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

HAAS CNC vertical machine #1

Memo

1-Machine per folio FB007

DWG REV: P24

FOLIO REV: Z4

0.00

ark 10/11/19

2 10

2- deburr rough edges

Work Order ID 63882

Page 2

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Start Date: 11/18/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

2011/11/14

2 0



QC

Memo

Quality Control

130

QC8- Inspect parts - second check

0.00

B 10.11.19



QC

Memo

Quality Control

140

Chemical Conversion Coat per QSI005 4.I

0.00

B 10.11.19



HandFinish

Memo

Hand Finishing

Work Order ID 63882

Page 3

Thursday, November 18, 2010 8:26:21 AM

Item ID: D4276-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Aft Beam

Start Date: 11/18/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

145

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

MASK AS PER DWG

2

AB

10.11.19

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2

10.11.22

180

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

2

AB

10.11.22

Work Order ID 63882

Page 4

Thursday, November 18, 2010 8:26:21 AM

Item ID: D4276-1

Accept



Setup Start



Revision ID: PREL'M

Stop



Item Name: Aft Beam

Start Date: 11/18/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

Rev. A. M.
*10-11-23**MF*
10-11-30

POSITIVE RECALL

EFFECTIVE 10-11-18 AUTH V

RELEASED _____ DATE _____

Picklist Print

Page 1

Thursday, November 18, 2010 8:26:26 AM

Work Order ID: 63882



Parent Item: D4276-1



Parent Item Name: A.. Beam

Start Date: 11/18/2010

Required Date: 11/30/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-11-17 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased	No			100	f	69.7988	3.052	6.425263			

6061-T6 Bar 1.00 x 4.00



Location	Loc Qty	Loc Code
MAT03	69.7988	
→ 107221	58.58	
→ 114352	11.2188	

3.213
3.213

on 10/18/18

DART AEROSPACE LTD	Work Order:	63882
Description: AFT BEAM	Part Number:	D4276-1
Inspection Dwg: D4276 Rev: PA2		Page 1 of 1

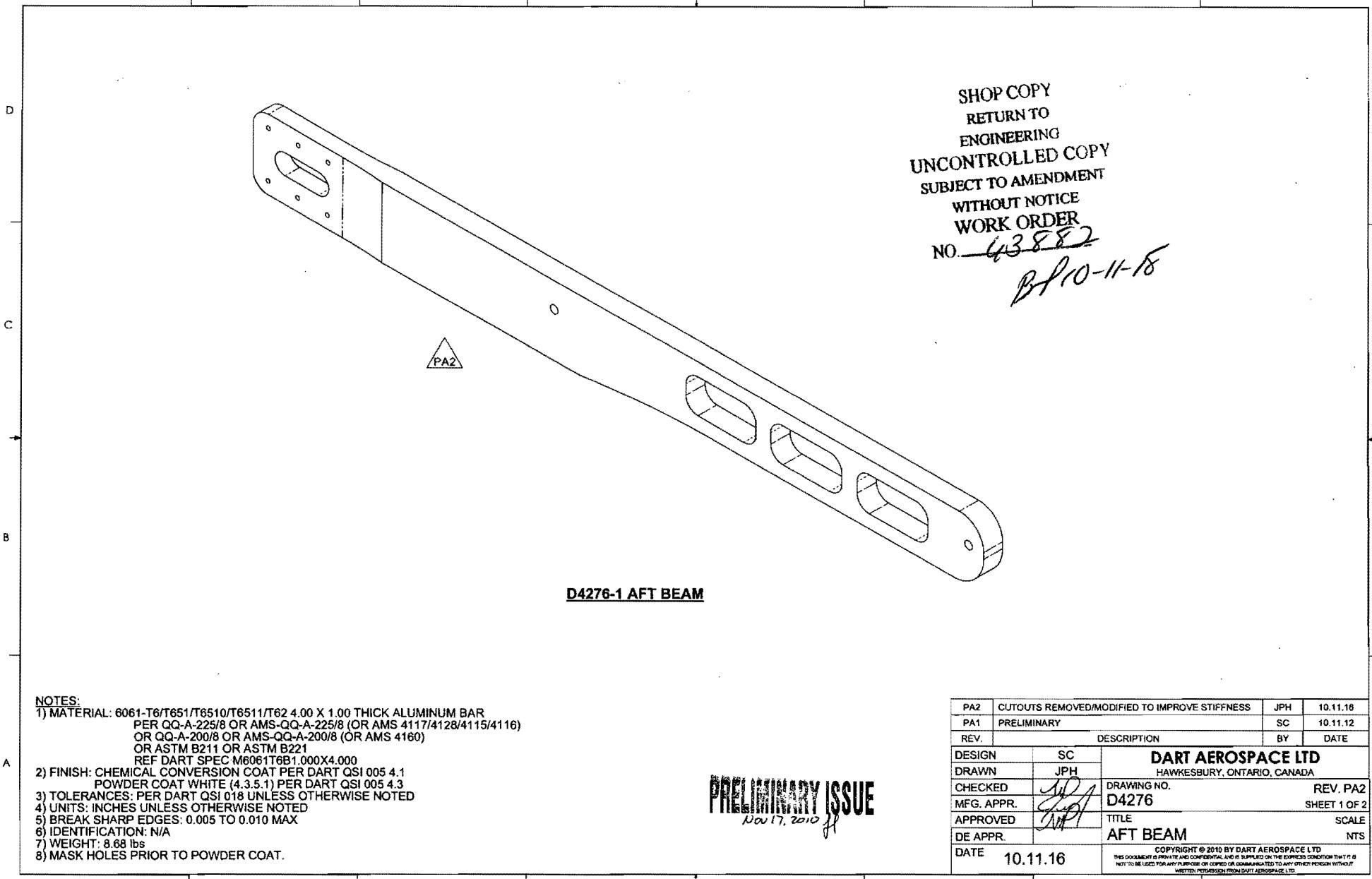
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	$\pm .030$	3.503	—		Vern	ML-7
3.00	$\pm .030$	3.000	—		"	"
1.250	$\pm .010$				"	"
2.75	$\pm .030$	2.754	—		"	"
.75	$\pm .030$.750	—		"	"
5.00	$\pm .030$	5.000	—		"	"
16.38	$\pm .030$	16.380	—		MTape	ML-2
20.500	$\pm .030$	20.500	—		"	"
14.380	$\pm .010$	14.380	/		"	"
4.50	$\pm .030$	4.500	—		Vern	ML-7
.734	$\pm .010$.730	—		"	"
.108	$\pm .010$.111	—		"	"
36.38	$\pm .030$	36.380	—		"	"
.95	$\pm .030$.932	—		"	"
.65	$\pm .030$.672	—		"	"
1.70	$\pm .030$	1.700	—		"	"
3.50	$\pm .030$	3.500	—	+	"	"
2.70	$\pm .030$	2.700	—		"	"
1.10	$\pm .030$	1.099	/		"	"
.60	$\pm .030$.597	—		"	"
2.300	$\pm .010$	2.298	—		"	"
.0.191	$\pm .005$.0.195	—		"	"
3.000	$\pm .010$	3.000	—		"	"

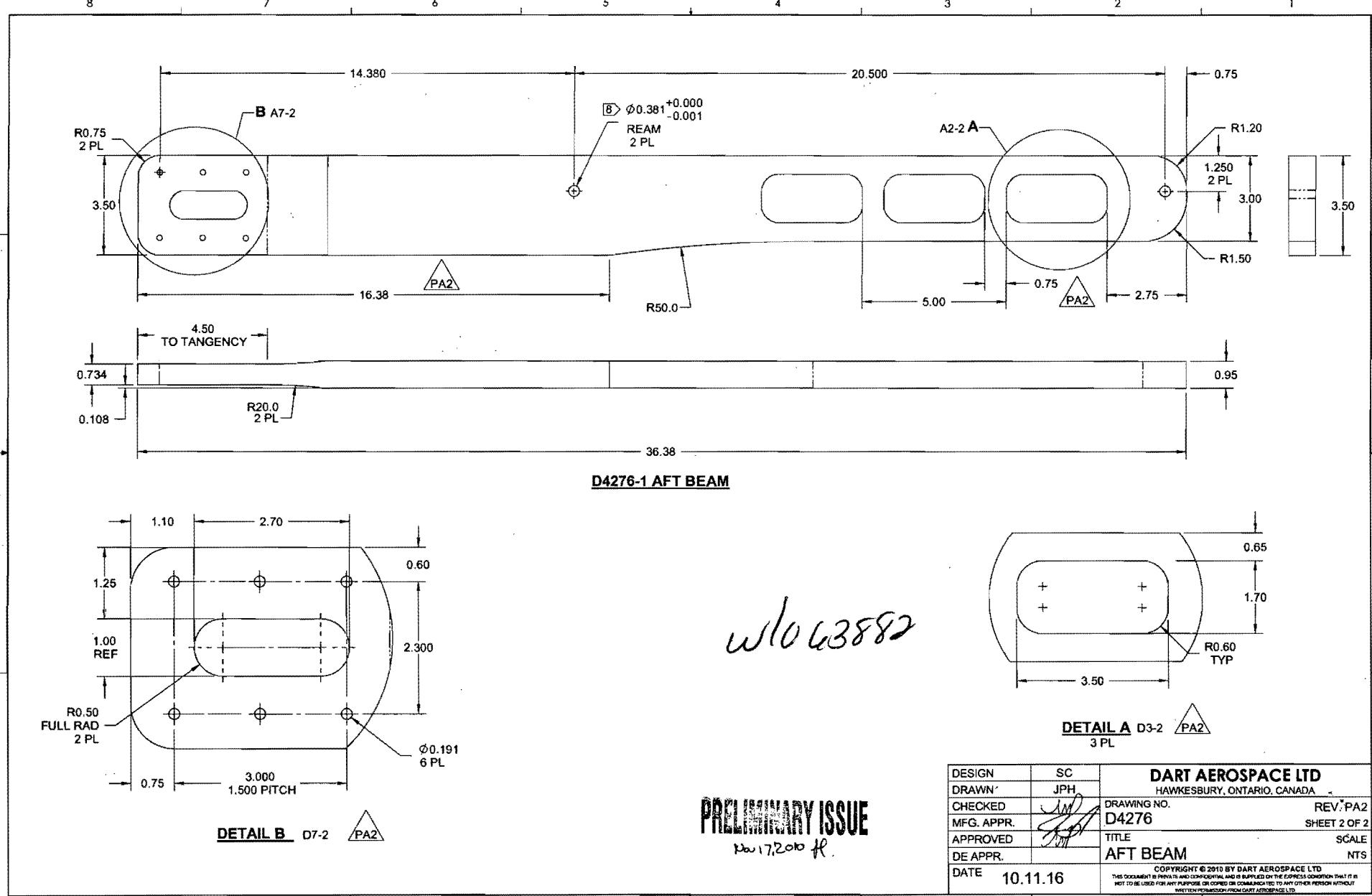
Measured by:	<i>mf</i>	Audited by:	<i>B</i>	Preliminary Approval:	
Date:	10/11/19	Date:	10-11-19	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1



DESIGN	SC	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>JW</i>	DRAWING NO.
MFG. APPR.	<i>JW</i>	D4276
APPROVED	<i>JW</i>	REV. PA2
DE APPR.	<i>JW</i>	SHEET 2 OF 2
DATE	10.11.16	SCALE
		NTS

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Receiving Report

Date: 10/4/12

Batch No: M 114352

Supplier: Magna

Dart P/O: 11570 11621

Packing Slip: Yes — No —
 Invoice: Yes — No —
 Receipt: Cash — Cr —

Release Note Attached: Yes — No — N/A —
 Waybill Attached: Yes — No —
 Shipment Complete: Yes — No — N/A —
 QC6 Inspection ✓ Yes — No — N/A —
 Work Order 10/4/12 N/A —

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
<u>See P10</u>	<u>4 B10</u>					

Initials of receiver (if shipment OK) Level 12 CZ

Production/Admin:

Date 10/4/13

Location

Received/Costing

Initial CZ



SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY, ON
K6A 1K7
Contact: CHANTAL

HAWKESBURY, ON
K6A 1K7
Ship Terms: PREPAID

SPECIAL INSTRUCTIONS
M114352
MTR:Y

Currency	Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS	ERYCK BLAIS	(613) 632-5200	(613) 632-1053	PO11621	
Sales Order	Terms	Ship Via	Date Ordered	Date Required	Date Shipped
W027937	NET 30 DAYS	NIR:R-557065-1	04/08/10	04/12/10	04/12/10

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
3		PC	ALUMINUM FLATS AFL 6061 T6 3/8" x 1" x R/L 20' 26 LB / 3 PC	L036797	47707	3
1		PC	AFL 6061 T6 1" x 4" x R/L 20' 94 LB / 1 PC	L034435	7892	1
1		PC	ALUM RECT TUBE ART 6061 T6 SC 2" x 4" x .120" x R/L 20' 34 LB / 1 PC DO NOT CHANGE MY PICKS PLEASE	L037453	729559	1
2		PC	ALUMINUM SHEET ASH 6061 T6 .125" x 48" x 96" 115 LB / 2 PC	L035652	3321301	2
Bundles: 1 Skids: 1				Approx	Weight:	269 LB

Received by: _____ Date: _____ Signature: _____

CAN ART
ALUMINUM EXTRUSION INC.

Material Test Report

Customer Ship To:

Magna Stainless Inc.

5775 Kieran St.

St-Laurent

QB H4S 0A3

Our Order: 833132 - 1

Your PO #: PO08068

Part #: 05885-000-240

Die: LS05885

Description: 1000 x 4.000

Alloy Temper: 6061 T6

Print Date: 12/8/2009

Chemical Properties

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	others each	others total	Al
0.40-0.8	0.7 max	0.15-40	0.15 max	0.8-1.2	0.04-0.35	0.25 max	0.15	0.05	0.15	remain

Mechanical Properties
Strength ksi

Test ID	Test Date	CastNum	Ultimate	Yield (2% Offset)	Elongation (2" gage length)
4501	12/4/09	7892	45.29	42.53	14.0

Applicable Specifications: ASTM B221-08 ASTM B308-02 ASTM B429 QQA200/8 QQA200/16

Can Art Aluminum Extrusion Inc. certifies that materials shipped under this order have been inspected and tested in accordance with Aluminum Association and agreed upon customer specifications. Can Art assumes no liability for additional costs which may be incurred during the customer's manufacture and sale of its products, and is subject only to the replacement of any materials not within agreed upon specifications provided written notification is received by Can Art within 30 days from the date of shipment.

Eric Hotte - Tensile Testing

Authorized

Evan Eng, Quality Assurance Mgr.

2008068-14892

Receiving Report

Date: 8/2/22 Batch No: M107221
 Supplier: MAGNA Dart P/O: 5756
 Packing Slip: Yes No Release Note Attached: Yes No N/A
 Invoice: Yes No Waybill Attached: Yes No N/A
 Receipt: Cash Cr Shipment Complete: Yes No N/A
 QC6 Inspection: 8F N/A
 Work Order: 8F N/A

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK)

Level 12

Production/Admin:

Date

08/02/25

Location

Received/Costing

RCR 7134

Initial

CZ

MAGNA

AN INNOVATION COMPANY

Argo Stainless division de CSM Inc.

35 Meloche Ave., Dorval (Québec) H9P 2W2

23 Melville Ave., Dorval (Quebec) H9P 2E1; (514) 631-1211; Fax: (514) 631-0013

800-363-6646
Toll-free: 1-800-363-6646

1-800-363-5646

ISO 9001-2000

Nº FACTURE / INVOICE NO.

154946

VENDU À - SOLD TO

DART

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY

ONTARIO

K6A 1K7

卷之三

EXPÉDIÉ À - SHIPPED TO

MEME - SAME

RECEIVED FEB 28 2008

FRAIS D'ADMINISTRATION DE 1 1/2% PAR MOIS (18% PAR ANNÉE) SUR COMPTE PASSÉ DU.
LE PRÉSENT CONTRAT SERA RÉGÉ PAR LES LOIS DE LA PROVINCE DE QUÉBEC ET COMMENCE
LE 1^{ER} JUIN 1990, EN VIGUEUR JUSQU'AU 1^{ER} JUIN 1992.

AYANT PRIS NAissance DANS LE DISTRICT JUDICIAIRE DE MONTREAL.
ADMINISTRATION CHARGES OF 1 1/4% PER MONTH (18% PER YEAR) ON OVERDUE ACCOUNTS.
THE PRESENT AGREEMENT SHOULD BE GOVERNED BY THE QUEBEC LEGISLATION AND SHOULD
BE CONSIDERED AS HAVING ORIGINATED IN THE JUDICIAL DISTRICT OF MONTREAL.

TOTAL →

882.00

Dart Aerospace Ltd

Dart Aerospace Ltd
 1270 Aberdeen St
 Hawkesbury, Ontario K6A 1K7
 Phone: (613) 632-3336
 Fax: (613) 632-4443

Receiving Slip

Date Feb 25, 2008	Page 1
Receipt Number RCP00007134	

Purchase From:

Magna Stainless
 525 avenue Meloche
 Dorval, QC H9P 2W2
 Canada

Ship To:

Main Finished Goods Location
 Dart Aerospace Ltd
 1270 Aberdeen St
 Hawkesbury, Ontario K6A 1K7

Reference	Description	Contact	Vendor Number	PO Number
			VC-MAG002	PO00005756

Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
	M6061T6B1000X0	6061-T6 Bar 1.0" x 4.0" PER AMS-QQ-A-200/8 OR AMS 4160 PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 MATERIAL: 6061-T6 OR 6061-T650/T6510/T6511/T62 BAR B/N107221	80.0000	f	10.500000	840.00	Feb 25, 2008

Comments:

MAGNA
GLOBAL

MAGNA STAINLESS DIV. DE CSM INC.
525 MELOCHE AVE.
DORVAL, QUEBEC H9P 2W2
(514) 631-1211 FAX: (514) 631-0013

COMMANDÉ
SALES ORDER

0164953

INDU À /
SHD TO:

LIVRÉ À /
SHIP TO:

INSTRUCTIONS SPÉCIALES / SPECIAL INSTRUCTIONS

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO

K6A 1K7

COMMANDE SALES ORDER	CODE DE CLIENT CUSTOMER CODE	BON D'ACHAT DU CLIENT CUSTOMER PURCHASE ORDER	N° DE TÉLÉPHONE DU CLIENT CUSTOMER TELEPHONE NUMBER	N° DE TÉLÉCOPIEUR DU CLIENT CUSTOMER FAX NO.			
0164953	DART	5756	613 632-5200	632-4443			
LIVRÉ VIA - SHIP VIA	CONDITIONS - TERMS	DATE COMMANDE DATE ORDERED	DATE REQUISE DATE REQUIRED	DATE LIVRÉE DATE DELIVERED			
NIR:R-557065-1	NET 30	Feb-21-08	Feb-22-08	15 26 EB			
CONTRÔLE DE QUALITÉ DU CLIENT REQUIS CUSTOMER QUALITY RELEASE REQ'D		CONTRÔLE DE QUALITÉ DE MAGNA REQUIS MAGNA QUALITY RELEASE REQ'D		PRÉPAYÉ PREPAID	À PERCEVOIR COLLECT		
QUALITÉ COMMANDÉE ORDERED	QUALITY A VENIR B/O	UNITÉ UNIT	N° DE COULÉE HEAT NUMBER	DESCRIPTION	QTE LIVRÉE QTY SHIPPED	PRIX PAR PRICE PER	INSTRUCTIONS DE L'USINE PLANT INSTRUCTIONS
4		PCS		6061-T6 ALUM FLAT 1 X 4 X 20'			4 PCS 42.0 Pc 84/1
T O T A L :							
							376 LBS

NOMBRE DE PAQ.
NUMBER OF BOL'S

MTR-AVEC COMMANDE
MTR'S-WITH ORDER

POSTE
MAIL TÉLÉCOPIEUR
FAX

PACKING SLIP / BON D'EMBALLAGE

Page: 1

08:49:12

20080221

N° DE COULÉE ÉTAMPER SUR LE CÔTÉ
HEAT NO. STAMP ONE END

REVISION 'K' - 07/01 - FORM 8008

MATÉRIEL REÇU EN BON ÉTAT PAR / MATERIAL RECEIVED IN GOOD CONDITIONS BY:

DART**Purchase Order**

Date Feb 21, 2008	Page 1
Purchase Order Number PO00005756	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FAXED**Vendor Address:**

Magna Stainless
525 avenue Meloche
Dorval, QC H9P 2W2
Canada
Phone (800) 363-6646
Fax (514) 631-0013

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-MAG002	Feb 21, 2008	N30	yours	Feb 22, 2008

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
80.0000	M6061T6B1000X040	6061-T6 Bar 1.0" x 4.0"	2/22/2008	No	10.500000	f	840.00

**MATERIAL CERTIFICATION
REQ'D UPON DELIVERY**

Comments:	Tax Summary: GST ONT PST	42.00 0.00	Less: included tax	0.00
			Subtotal	
			Total tax	42.00
			Total purchase order in CAD Dollars	882.00

Entered By: CLAVOIE

Approved By: _____



325 rue Avro
Pointe-Claire QC H9R 5W3

Téléphone (514) 697-5120
Fac-simile (514) 694-8310

Test de dureté Rockwell Rockwell Hardness Test

Client / Customer : MAGNA STAINLESS INC.

Adresse / Address : 525, Meloche
Dorval (Québec)
H9P 2W2

commande Indalex / Indalex order # : 7100595

bon de commande / Purchase order # : 071484-EB

de matrice / Die # : MS 16386 Description : 4.00" X 1.00"FLAT BAR

Alliage & trempage / Alloy & temper : 6061-T6

Contrôle / Control # : 58937-1

Coulée / Cast # : 41756

Dureté Rockwell E / Rockwell E hardness : 93 HRE Min. requis / Min. required : 88 HRE Max. permis / Max. permitted : 100 HRE

Composition chimique typique / Typical chemical composition :

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti
6063	0.20 - 0.60	0.35 Max	0.10 Max	0.10 Max	0.45 - 0.90	0.10 Max	0.10 Max	0.10 Max
6005	0.60 - 0.90	0.35 Max	0.10 Max	0.10 Max	0.40 - 0.60	0.10 Max	0.10 Max	0.10 Max
6005A	0.66 - 0.74	0.14 - 0.28	0.08 - 0.16	0.18 - 0.26	0.46 - 0.54	0.03 Max	0.05 Max	0.05 Max
6061	0.40 - 0.80	0.70 Max	0.15 - 0.40	0.15 Max	0.80 - 1.20	0.04 - 0.35	0.25 Max	0.15 Max
6351	0.7 - 1.3	0.5 Max	0.10 Max	0.40 - 0.80	0.40 - 0.80	—	0.20 Max	0.20 Max

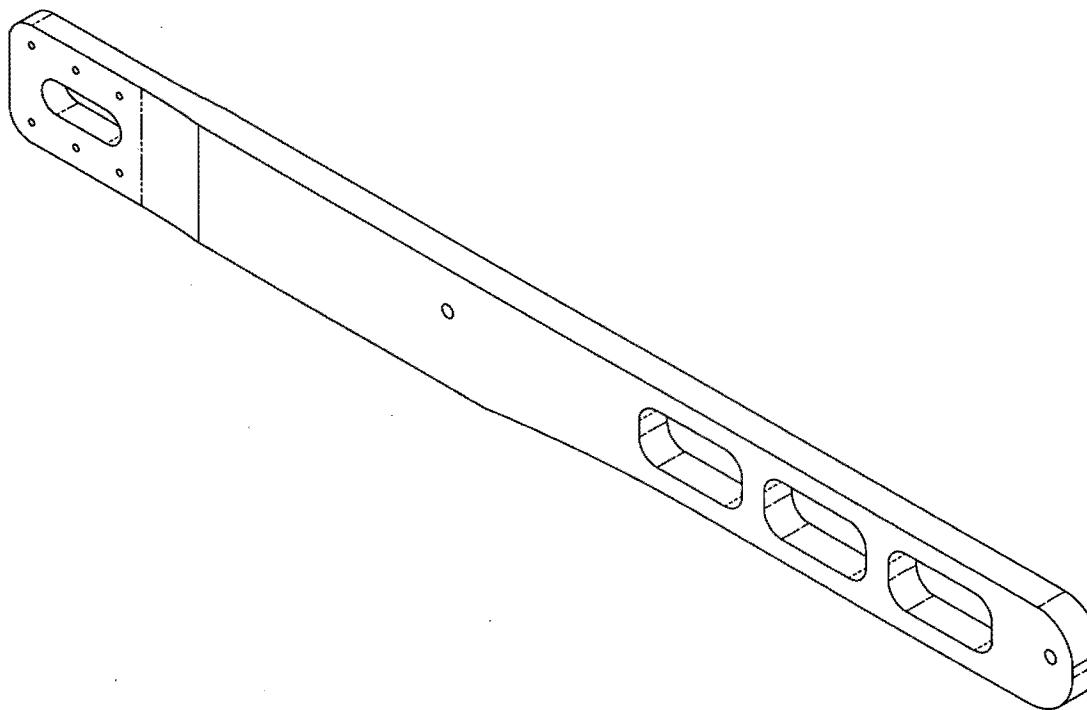
Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-221 excepté pour la section 8.2 (nombre de spécimen) et AMS QQA 200/8 excepté pour la section 4.2.3.1 (nombre de spécimen) qui sont déterminés par les exigences du client.

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221 except for section 8.2 (number of specimen) and AMS QQA 200/8 except for section 4.2.3.1 (number of specimen) which is determined by customer requirement.

Sincèrement vôtre,
Yours truly,

date : 2007-10-18

Bruno Morency
Technicien de la qualité
Quality technician



D4276-1 AFT BEAM

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 8.68 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT.

A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH	DRAWING NO.	REV. A
CHECKED	#	D4276	SHEET 1 OF 2
MFG. APPR.	#	TITLE	
APPROVED	#	SCALE	
DE APPR.	#	AFT BEAM	
DATE	10.11.25	NTS	

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8 7 6 5 4 3 2 1 0

